

Work Order ID 83361

83361

Page 1

April-17-12 2:22:19 PM

Item ID: D3278-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Support Assembly

Stop

NS2

Start Date: 17/04/2012 Start Qty: 40.00

40

Cust Item ID:

Required Date: 01/05/2012 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/17

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3278	Rev C								
100		0.00							
100	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Rivet spacers with support as per Dwg D3278.								
110		0.00							
110	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
120		0.00							
120	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Assemble support as per Dwg D3278.***DO NOT TIGHTEN BOLTS***Identify as D3278-041								

40x ϕ 12/04/19

40 ϕ 12/04/19

40 ϕ 12/04/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Support Assembly

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40

Cust Item ID:

Required Date: 01/05/2012 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location: 481

0.00

140

Packaging

Memo

0.00

Packaging

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

40

8

12/04/19

12/4/23 (40)

12/4/23

12/04-23

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 83361

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Parent Item: D3278-041

D3278-041

Parent Item Name: Support Assembly

Start Date: 17/04/2012

Required Date: 01/05/2012

Start Qty: 40.00

Required Qty: 40.00

Comments:

IPP: A04.04.19New issueKJ/JLM

IPP B 07.08.21 Chg rivet per PAR185 EC Verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3278-1		Manufactured	No			100	Each	61.0000	1	40			
---------	--	--------------	----	--	--	-----	------	---------	---	----	--	--	--

D3278-1

Support

Location

Loc Qty

Loc Code

GA

61

73412

1

80579

60

D3278-2		Manufactured	No			100	Each	1.0000	1	40			
---------	--	--------------	----	--	--	-----	------	--------	---	----	--	--	--

D3278-2

Support

Location

Loc Qty

Loc Code

CA

1

74879

1

D3278-3		Manufactured	No			100	Each	71.0000	1	40			
---------	--	--------------	----	--	--	-----	------	---------	---	----	--	--	--

D3278-3

Spacer

Location

Loc Qty

Loc Code

GA

71

70984

2

77061

14

80166

55

**

**

**

12/04/19

12/04/19

12/04/19

880580

40x

13

27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Work Order ID: 83361

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Parent Item: D3278-041

D3278-041

Parent Item Name: Support Assembly

Start Date: 17/04/2012

Required Date: 01/05/2012

Start Qty: 40.00

Required Qty: 40.00

MS21042L4

Purchased

No

100

Each

3,495.000

2

80

MS21042L4

Nut

**

EP 12/04/19

Location

Loc Qty

Loc Code

ST300

3495

116188

5

119017

4

119075

1486

121011

2000

80

AN4-13A

Purchased

No

120

Each

1,315.000

2

80

AN4-13A

Bolt

**

EP 12/04/19

Location

Loc Qty

Loc Code

ST357

1315

119449

39

120187

36

120422

340

120770

400

121162

500

80

AN960JD416

NAS1149D0463J Purchased

No

120

Each

10.0000

4

160

AN960JD416

Washer

**

EP 12/04/19

LD M 12/01/11
1600

Location

Loc Qty

Loc Code

ST351

10

116289

10

April-17-12 2:22:23 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Parent Item: D3278-041

D3278-041

Parent Item Name: Support Assembly

Start Date: 17/04/2012

Required Date: 01/05/2012

Start Qty: 40.00

Required Qty: 40.00

D2230-1

Manufactured No

120

Each

137.0000

2

80

D2230-1

Lug

**

PS 12/04/19

Location

Loc Qty

Loc Code

ST

4

78596

4

ST480

133

67826

6

70974

3

80008

124

MS20426AD3-6

Purchased

No

120

Each

4,857.000

4

160

MS20426AD3-6

Rivet

**

PS 12/04/19

Location

Loc Qty

Loc Code

ST316

4857

105055

107

116289

2134

120123

2616

160

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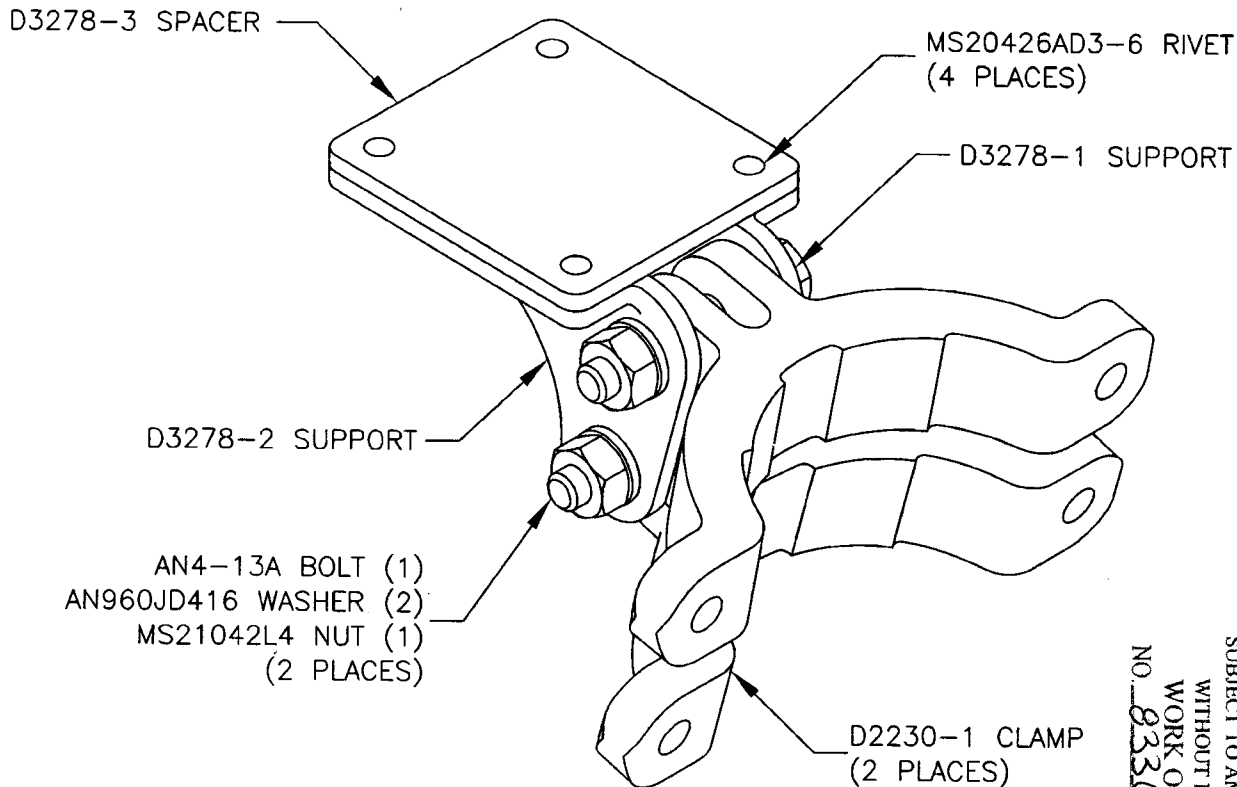
NOTE: Date & initial all entries

DART

DESIGN <i>GP</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

RELEASED
07-08-06

D3278-041 SUPPORT ASSEMBLY



Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83361 MJS
12/04/17

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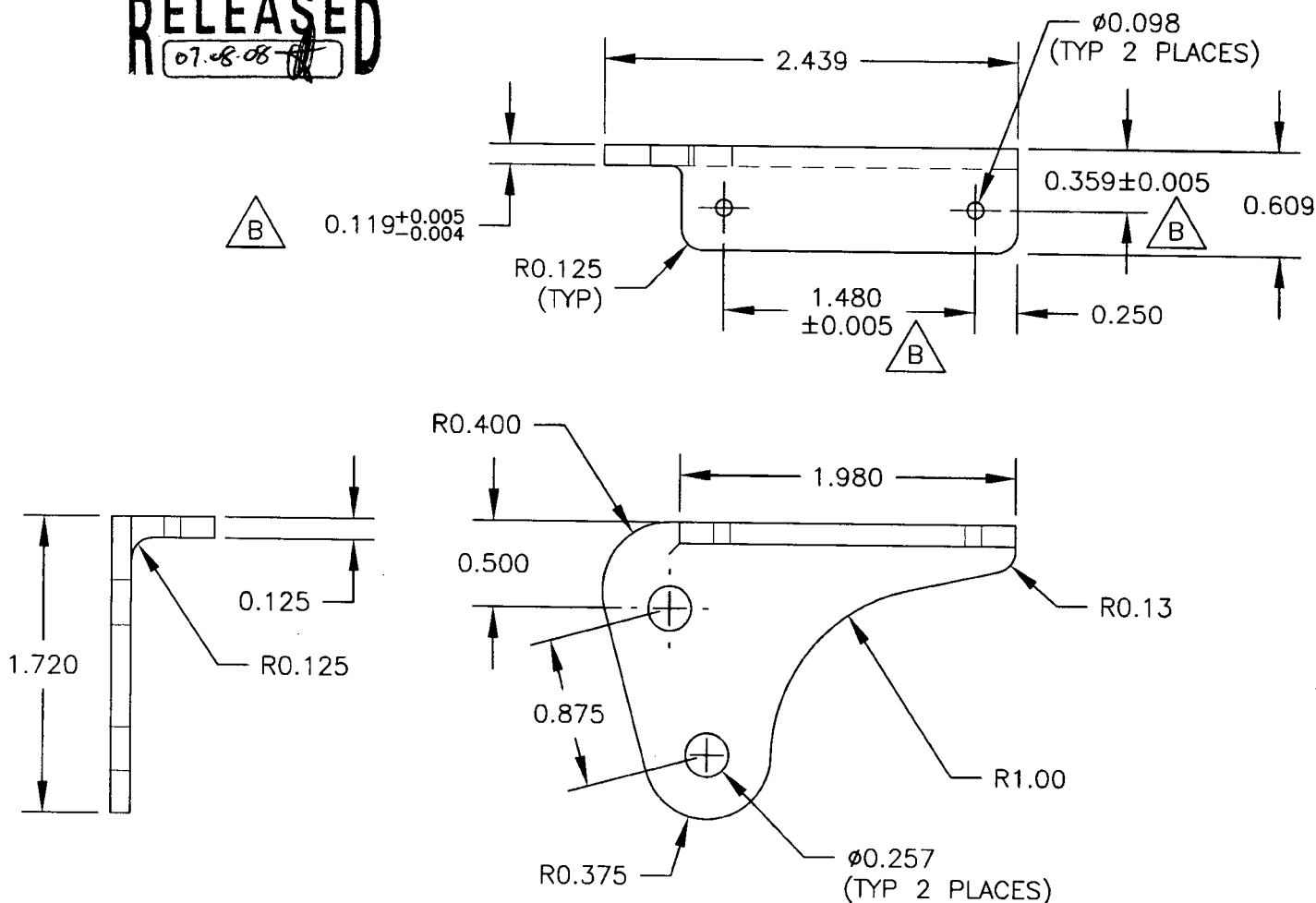
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DESIGN <i>qp</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07.08.08



D3278-1 SUPPORT (SHOWN)

D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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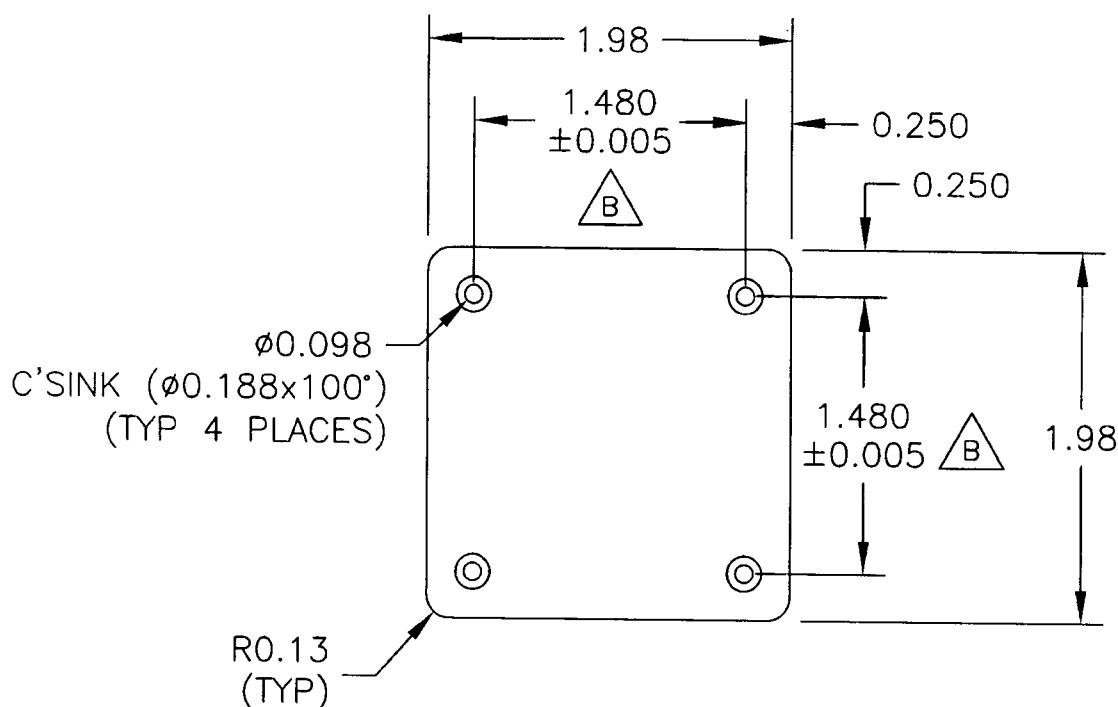
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DESIGN <i>GP</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>JB</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07.08.08



D3278-3 SPACER

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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